

Monday, 03/11/2008 10:39:58 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name*	: BASKET BASE ASSEMBLY (350)		
Job Number	: 43142A			Part Number	: D2221		
Estimate Number	: 10189			Drawing Number	: D2221 REVG		
P.O. Number	:			Project Number	: N/A		
This Issue	: 03/11/2008	S.O. No.	:	Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 14/11/2008		
Previous Run	: 42721A			Qty:	1	Um:	Each
Written By	:						
Checked & Approved By	: JD 08.11.03						
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Pick:		
	Qty Part Number	Description Batch	
	4 D3166-1	RIB <u>B43165</u>	<u>SAD 08-12-10</u>
2.0	D22323	Basket Hinge	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
	Pick:		
	Qty Part Number	Description Batch	
	2 D2232-3	Hinge bracket <u>1339334</u>	<u>SM 08/12/15</u>
3.0	D2325	Support Gusset (350 Basket)	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
	Pick:		
	Qty Part Number	Description Batch	
	4 D2325	Support Gusset <u>B39913</u>	<u>SM 08/12/11</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 03/11/2008 10:39:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 43142A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2327-3 Bushing *B39560*

NY 08/12/15

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket *B40895*

NY 08/12/15

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim *B40392*

NY 08/12/15

7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal *M107966* *(4)*
M109384

SAN 08/12/11 ①

8.0 M304TS0750W065 304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SStubing
Batch: *M109731*

SAN 08-12-10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 ✓

2-Drill hole in D2221-3 as per Dwg D2221 ✓

3-Deburr ✓

4-Remove all markings on material before welding ✓

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required ✓

M 08/12/15

10.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0 QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/12/16 (2)

12.0 POWDER COATING

POWDER COATING



(1X)

Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

3:30 OF M-k 08/12/17

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:20 OF M-k 08/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 08/12/18

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 KJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

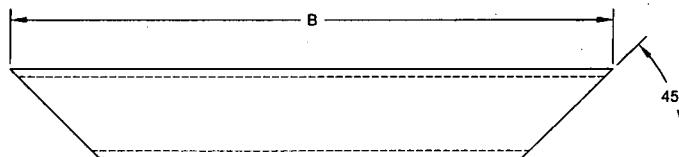
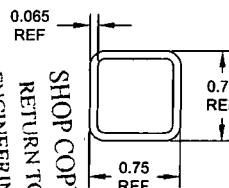
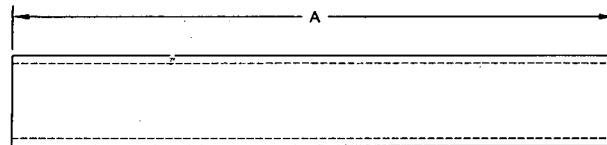
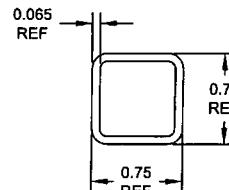
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



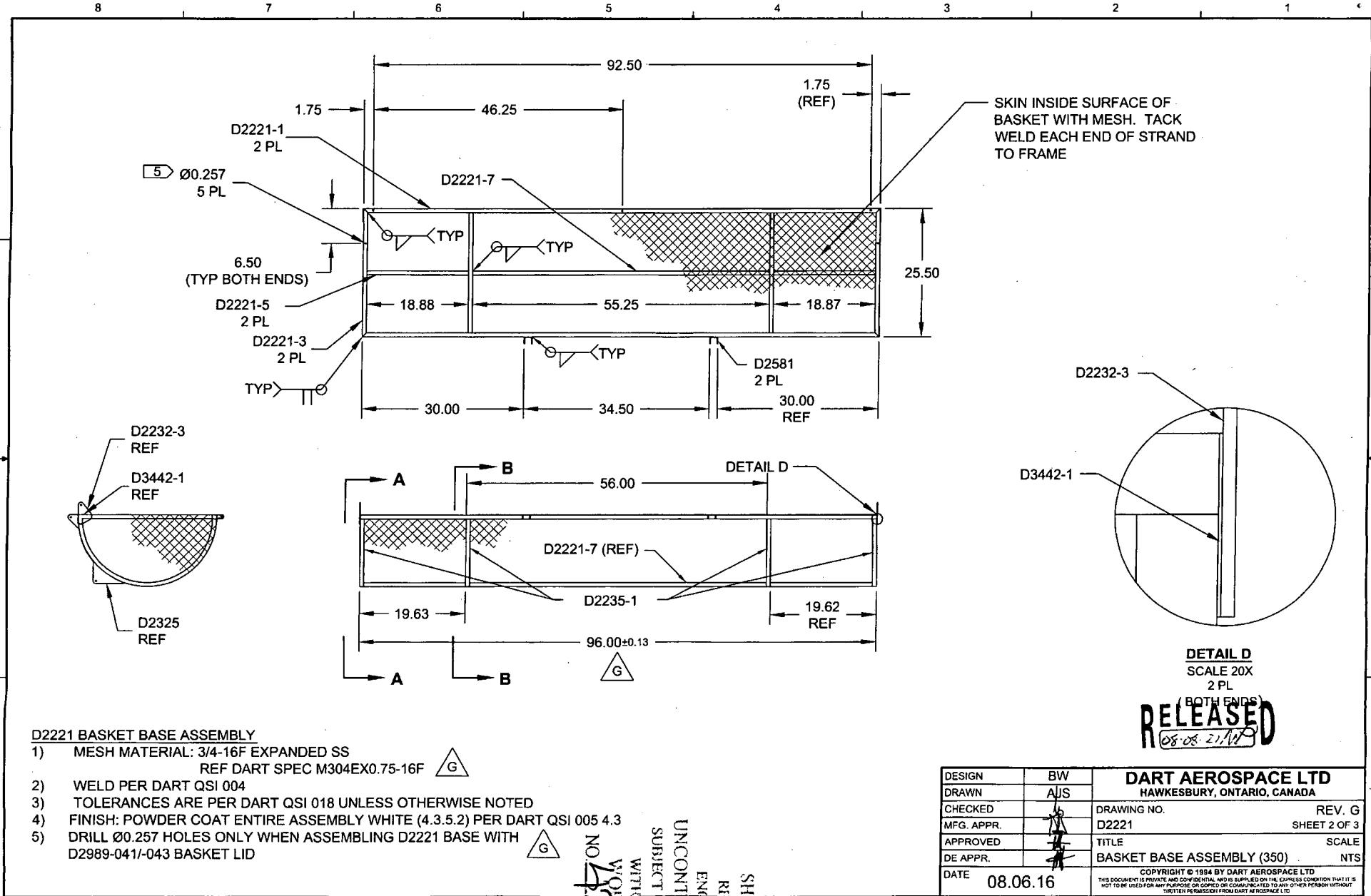
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- D2221-1-3/-5/-7
 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
 REF. DART SPEC M304TS0.750W.065
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES

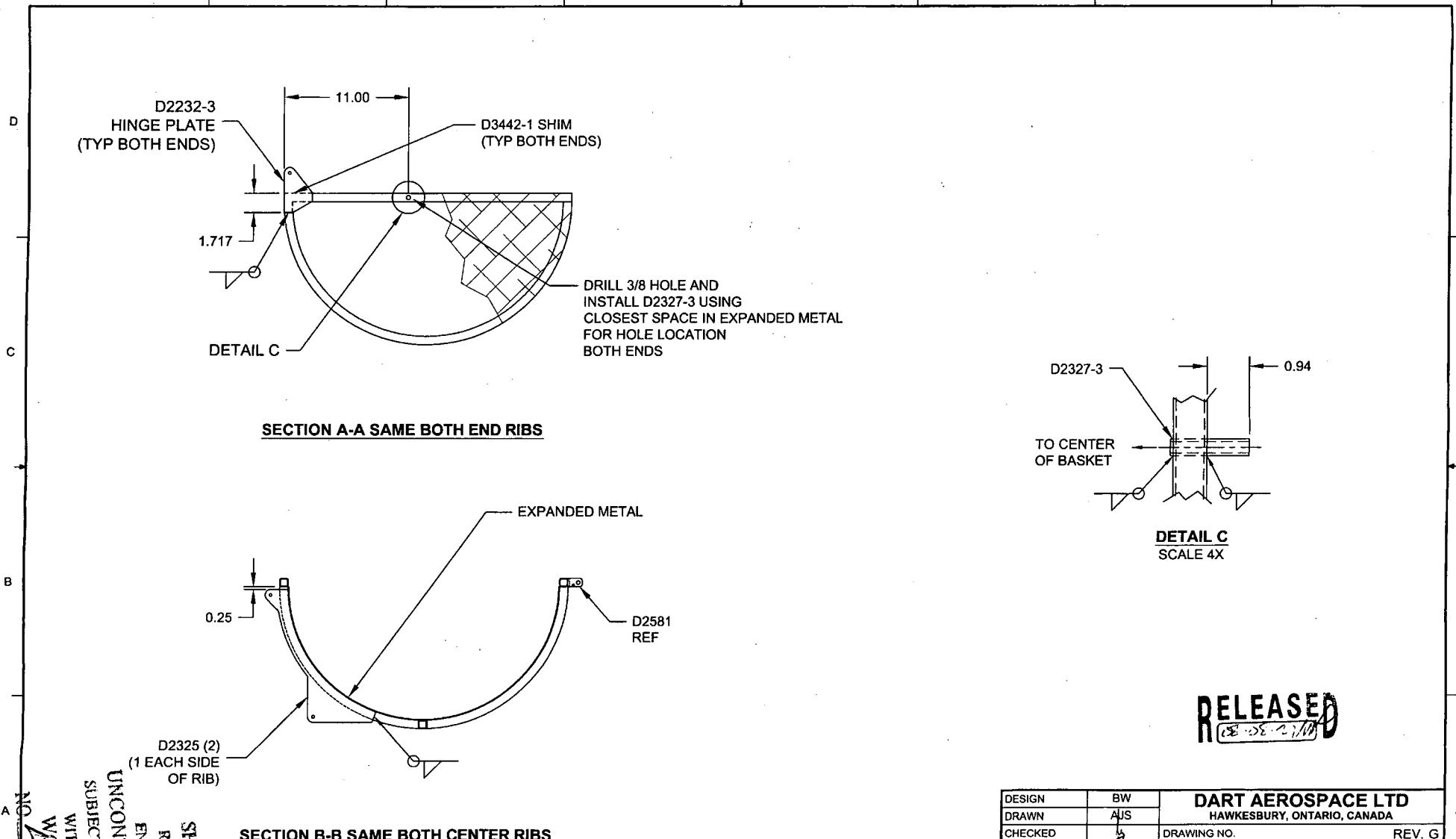
G

RELEASED
06-08-21/MH

G	MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B.5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF. NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. G
CHECKED		D2221	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350)	
DE APPR.		NTS	
DATE	08.06.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



8 7 6 5 4 3 2 1



RELEASED
(8-28-11)

DESIGN	BW	DART AEROSPACE LTD
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. G
APPROVED		D2221
DE APPR.		SHEET 3 OF 3
DATE	08.06.16	TITLE
		SCALE
		BASKET BASE ASSEMBLY (350) NTS
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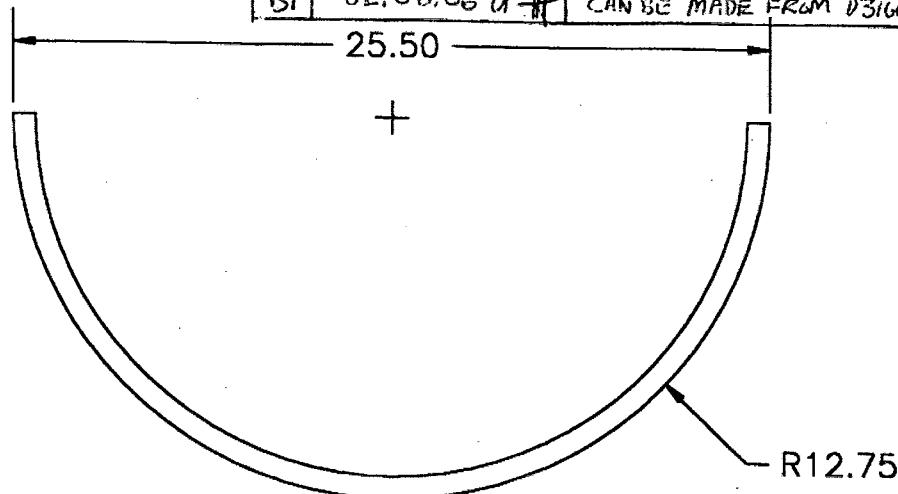
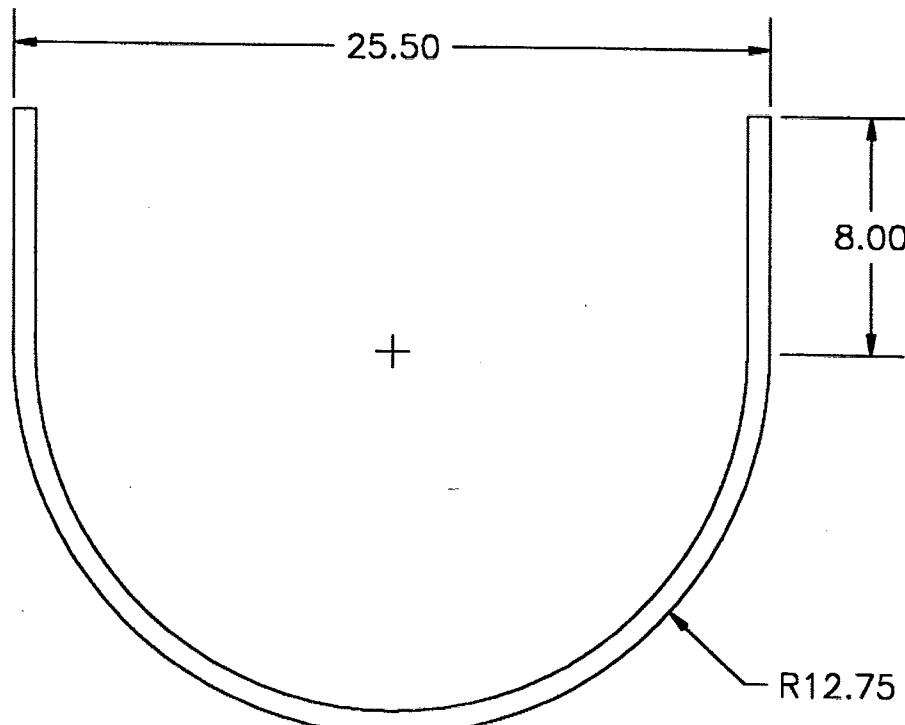
A
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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		TITLE SCALE BASKET RIBS

REV. B
SHEET 1 OF 1

B1 02.08.06 U-1 CAN BE MADE FROM D3166-1

RELEASED
R 960507D2235-1D2235-3

CAN BE MADE FROM D3166-1 Bi

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

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WORK ORDER